



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3195-043
Job Sheet 190122



Part No: D3195-043

Job Qty: 1 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 3/15/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV B IPP Rev:A New Issue 05-11-08 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	1 pcs		3/15/19	0.00	0.02	Bandsaw - 1		mmk 19/02/19
110	HAAS 4 Axis - B4B	1 pcs		3/15/19	0.36	0.55	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	1 pcs		3/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mmk 19/02/23
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		



Container No: S154393



Part: D3195 - 043

Job No: 190122

Serial No/Batch: S154393

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/15/19

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

130 QC 8	1 pcs	3/15/19	0.00 0.00	QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	De 19-02-23
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
140 Handfinish - 1-1 Chemical- B4B	1 pcs	3/15/19	0.00 0.05	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	P.R 19/2/25
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

Entered: _____ Date: _____



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Other/Details:					

150 Powdercoat - 3 Grey Sand - B4B	1 pcs	3/15/19	0.00 0.03	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	1 pcs	3/15/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
170 Small Fab - 2 - B4B	1 pcs	3/15/19	0.00 0.15	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
180 QC 5	1 pcs	3/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
190 Packaging 3-1 - Stock - B4B	1 pcs	3/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	

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Other/Details:					

					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	502.1
					Packaging 3 - 28 - B4B	8 FEB 28 2019
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
200 QC 21 - SA	1 pcs	3/15/19	0.00 0.00		QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21
					QC 21 - SA - 53	8-30

MAR 01 2019

Part Op 100 - (Bandsaw) Cut blanks: (1.250" x 1.500") x 3.60" long x10 MAT 002
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Small Fab) 1-Lightly Sand bonding surface 2-Bond D3195-7 into D3195-13as per Dwg D3195
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3195-7 S150484	Pad	1 pcs (1 ea)	100-Bandsaw - 1	S136474
M6061T6B1.250X1.500	6061-T6 Bar 1.250 X 1.500	.3000 ft (.3 ea)	170-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D3195-7	1	0	0
170-Small Fab - 2 - B4B	M6061T6B1.250X1.500	0	15	0

Part Specifications

Specifications could not be found.

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____ Date : _____ Description: _____	DISPOSITION	DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;"> ☐ (Non-AW) ☐ Eng. Coord. ☐ Packaging </td> <td style="width: 70%;"> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Engineering</td> <td style="width: 50%;">Water Jet</td> </tr> <tr> <td>Supplier</td> <td>Quality</td> </tr> </table> </td> </tr> </table>	☐ (Non-AW) ☐ Eng. Coord. ☐ Packaging	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Engineering</td> <td style="width: 50%;">Water Jet</td> </tr> <tr> <td>Supplier</td> <td>Quality</td> </tr> </table>	Engineering	Water Jet	Supplier	Quality
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Engineering	Water Jet							
Supplier	Quality							
Container No: S154393 Part: D3195 - 043 Job No: 190122 Serial No/Batch: S154393 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Doc: 02/26/19		MRB (QSI042)						
		Completed By						
		Lead hand / Supervisor						
		QC / QA Coordinator						
Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;"> ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors </td> <td style="width: 25%;"> ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled </td> <td style="width: 25%;"> ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function </td> <td style="width: 25%;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up </td> <td style="width: 20%;"> ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread </td> </tr> </table>			☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
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